

Date: Tuesday, 7/1/2008 2:34:33 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BASE
Job Number : 40193	
Estimate Number : 13031	
P.O. Number :	Part Number : D36513
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D3651 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 37165	Material :
Written By :	Due Date : 7/25/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JB 08 07 01</u>	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC	
Est Rev:B ECN 1113P 08-01-22 DD	
Est Rev:C ecn1162 08-04-02 DD verified by: EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.4977 sf(s)/Unit Total : 1.9908 sf(s)  
304/316 SS sheet 26 ga (0.018" thick)  
Batch: 108415 JB 8-7-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3651  
Dwg Rev: B  
Prog Rev: B

JB 8-7-4



2-Deburr if necessary JB 8-7-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JB 8-7-4

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Soe107104 (S)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Form as per Dwg D3651


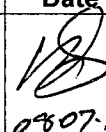
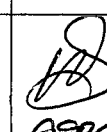
JB 08 07



PRO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3651-3 PAR #: N/A Fault Category: Prod / ~~QA~~ ~~MS~~ ~~ma~~ ~~180007~~ NCR: ☒ Yes ☐ No DQA: D Date: 08/07/09  
 QA: N/C Closed: D Date: 08/07/09

NCR: <u>40193</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-07-15	5	Two parts bent out of tolerance *		Scrap & destroy no replace	 08-07-16	S 08-07-16	 08-07-16	J 08-07-16

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:34:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 40193

Part Number: D36513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508 (7/1/08) (x3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: GA

508 08/07/17 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18

Job Completion



10807.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

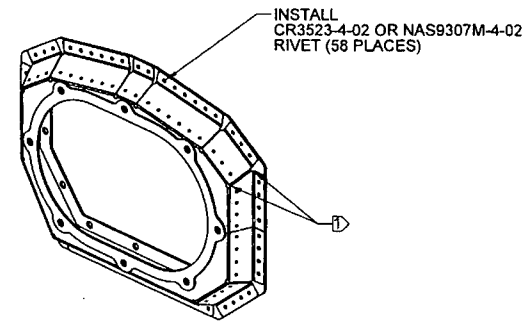
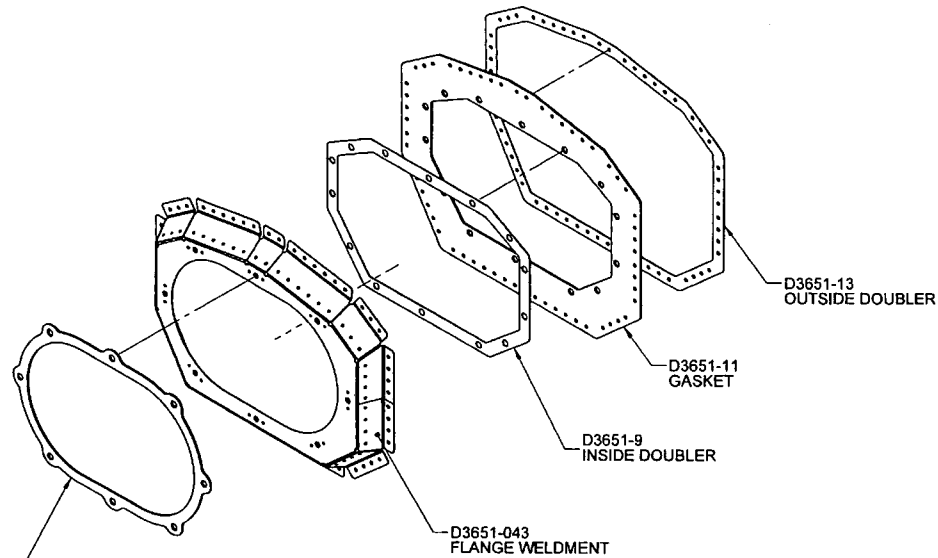
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



**PART LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-1 GASKET  
②

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NO. 140183

**D3651-041 AFT BASE ASSEMBLY**

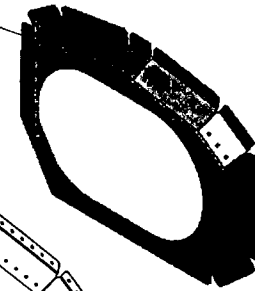
**D3651-041 NOTES:**

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

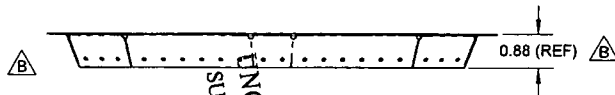
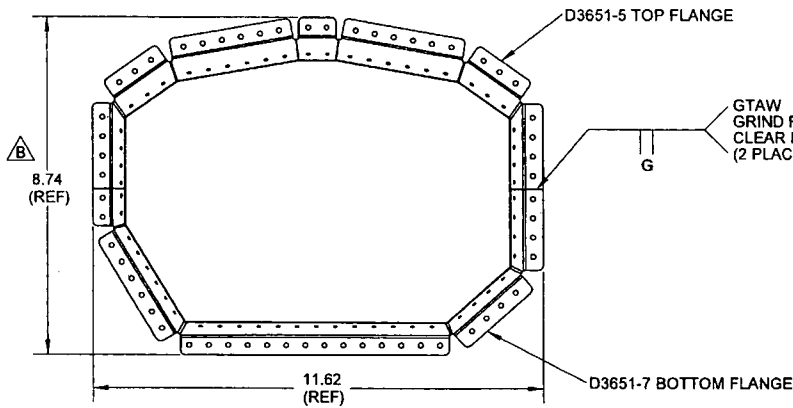
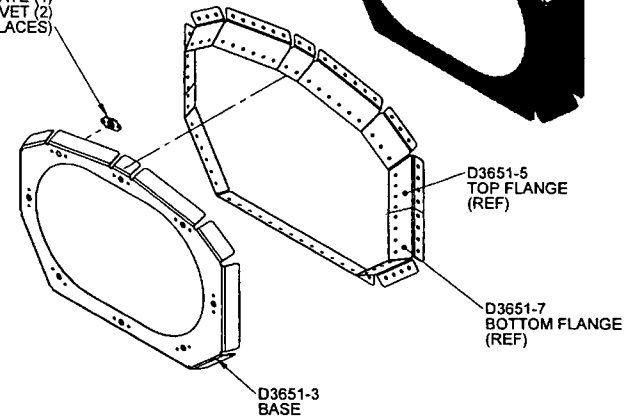
RELEASED  
08-03-27 MP

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	RF	DRAWING NO.	REV. B
APPROVED	RF	D3651	SHEET 1 OF 9
DE APPR.	RF	TITLE	SCALE
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TRANSFER DRILL  $\varnothing 0.129$  (#30 DRILL)  
FROM D3651-5/-7 TO D3651-3  
INSTALL CR3523-4-02 OR NAS9307M-4-02  
RIVETS (57)



MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



### D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

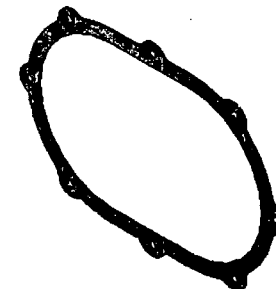
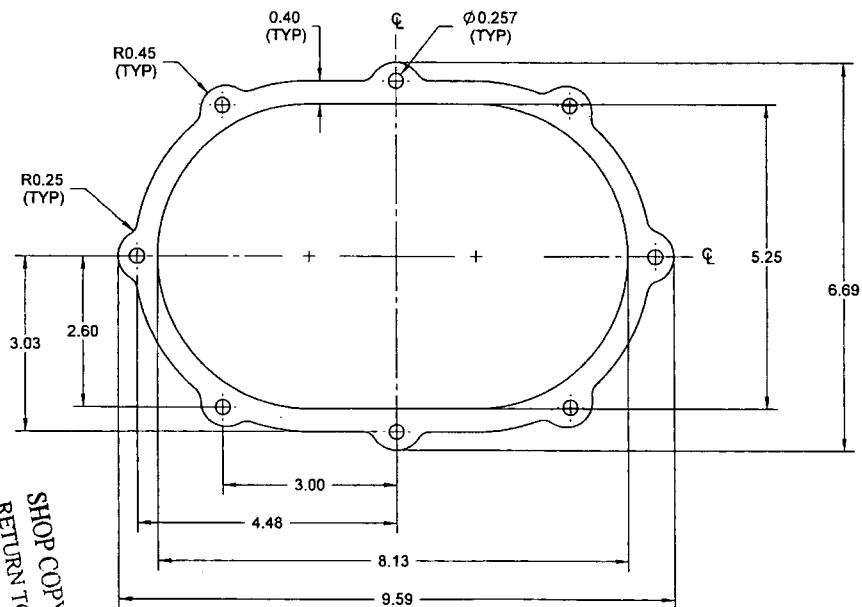
RELEASED  
11-03-03 27/40

#### D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

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**D3651-1 GASKET**

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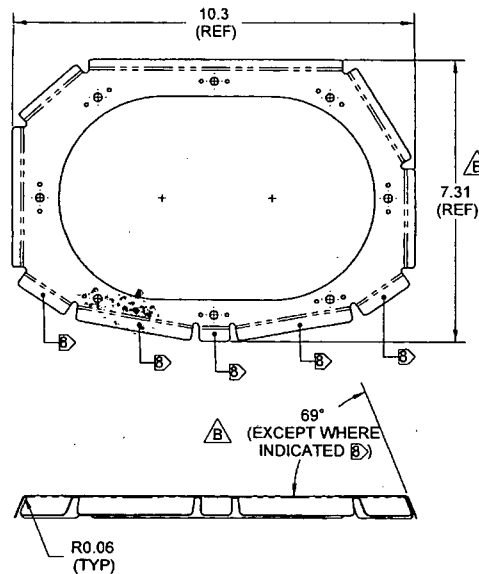
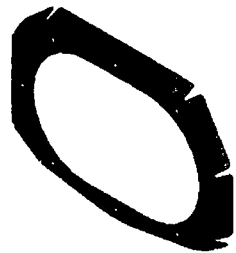
**NOTES:**

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT  $\phi$
- 8) WEIGHT: 0.09 lbs

RELEASED  
08-03-27

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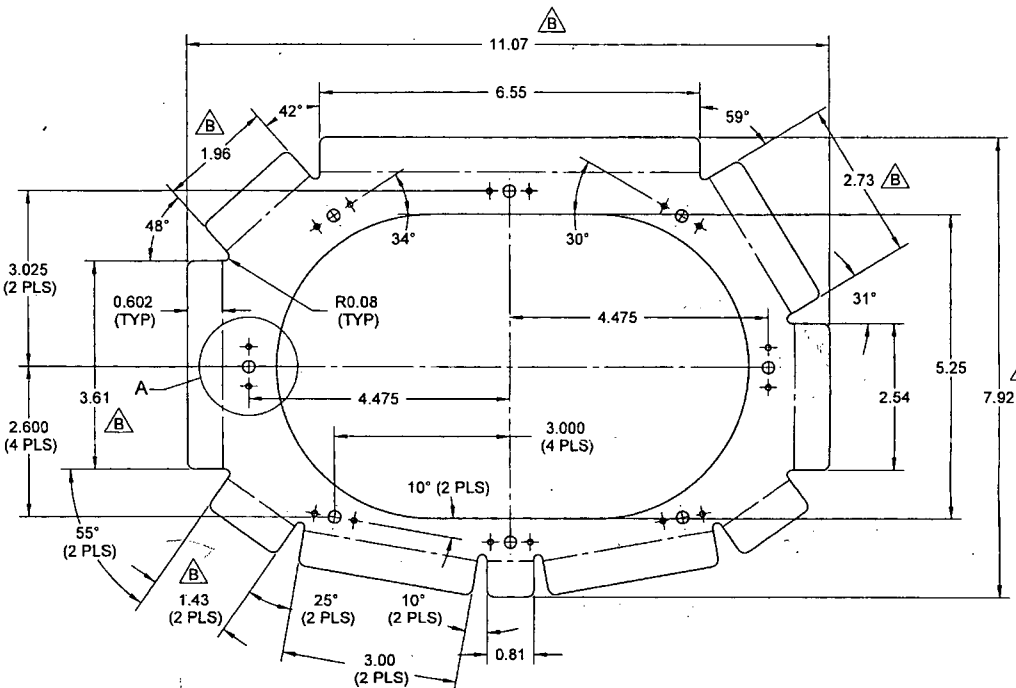


**D3651-3 BASE**  
(MAKE FROM D3651-3F FLAT PATTERN)

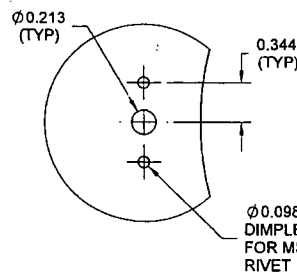
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED

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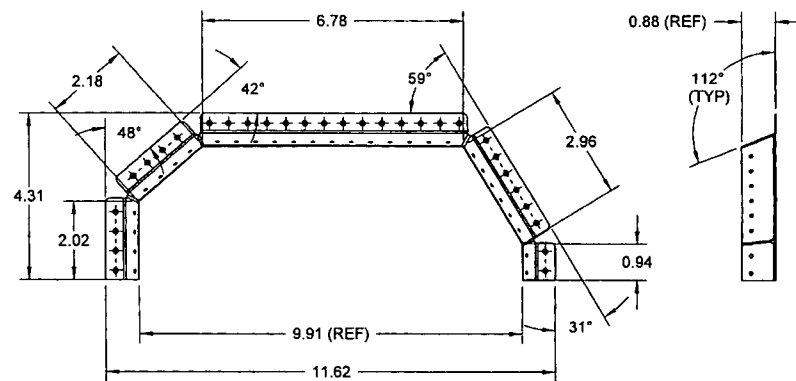
**D3651-3F FLAT PATTERN**



**DETAIL A**

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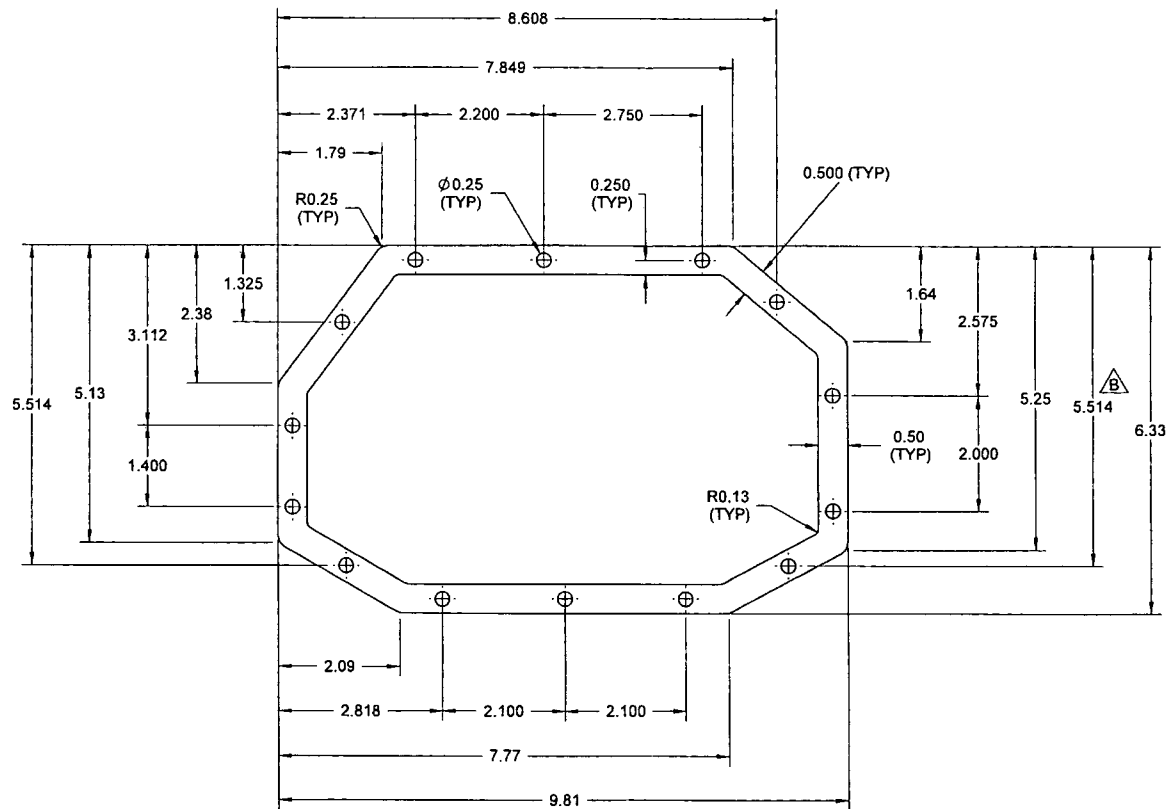


**D3651-7 BOTTOM FLANGE BEND DETAIL**  
**(MAKE FROM D3651-7F FLAT PATTERN)**

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 0.02 lbs

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DRAWN	RF		SHEET 6 OF 9
CHECKED	NE		SCALE
MFG. APPR.	RF		1:3
APPROVED	RF		
DE APPR.	RF		
DATE	08.01.07		



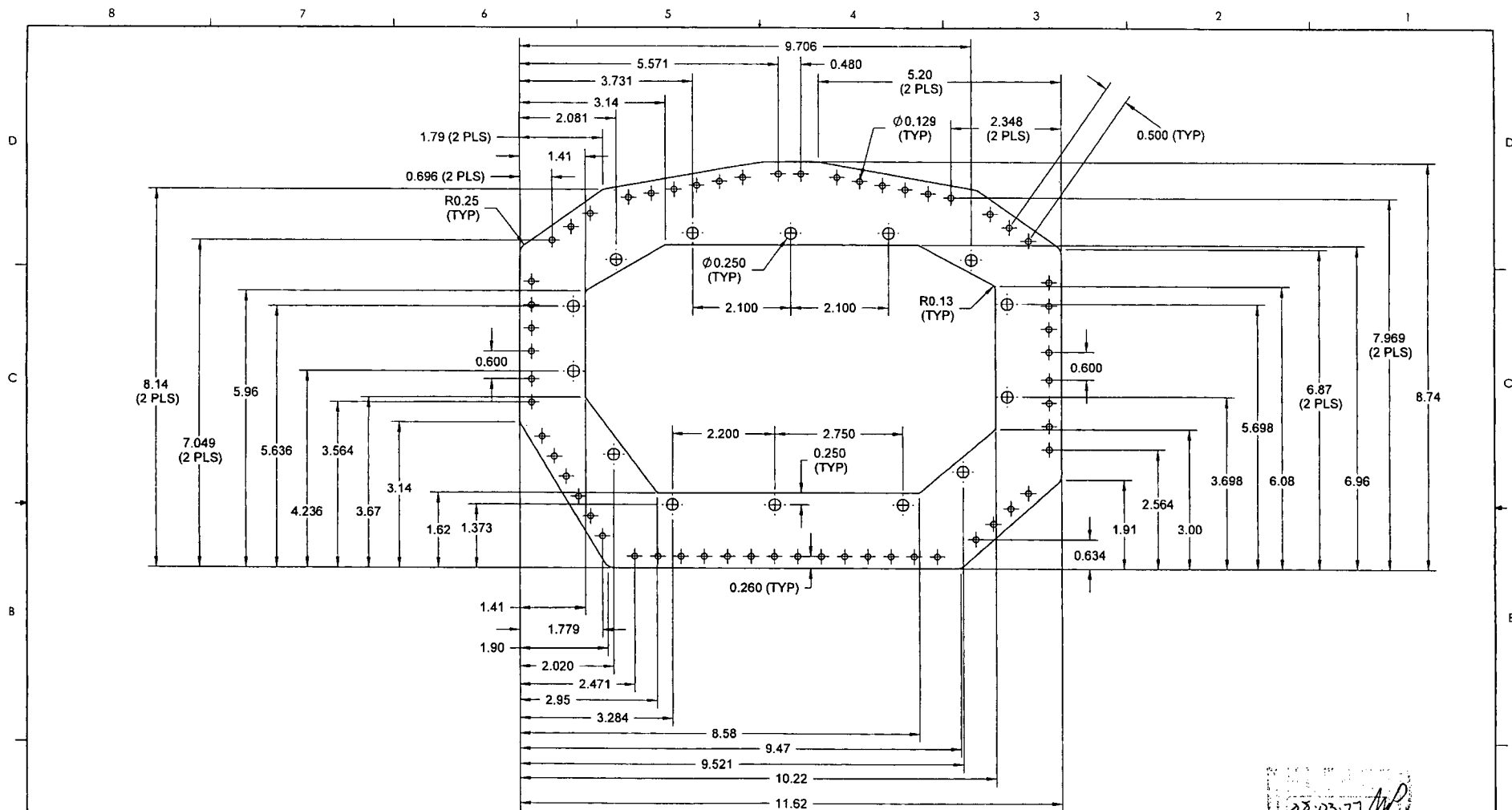
**D3651-9 INSIDE DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5018 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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# NOTES:

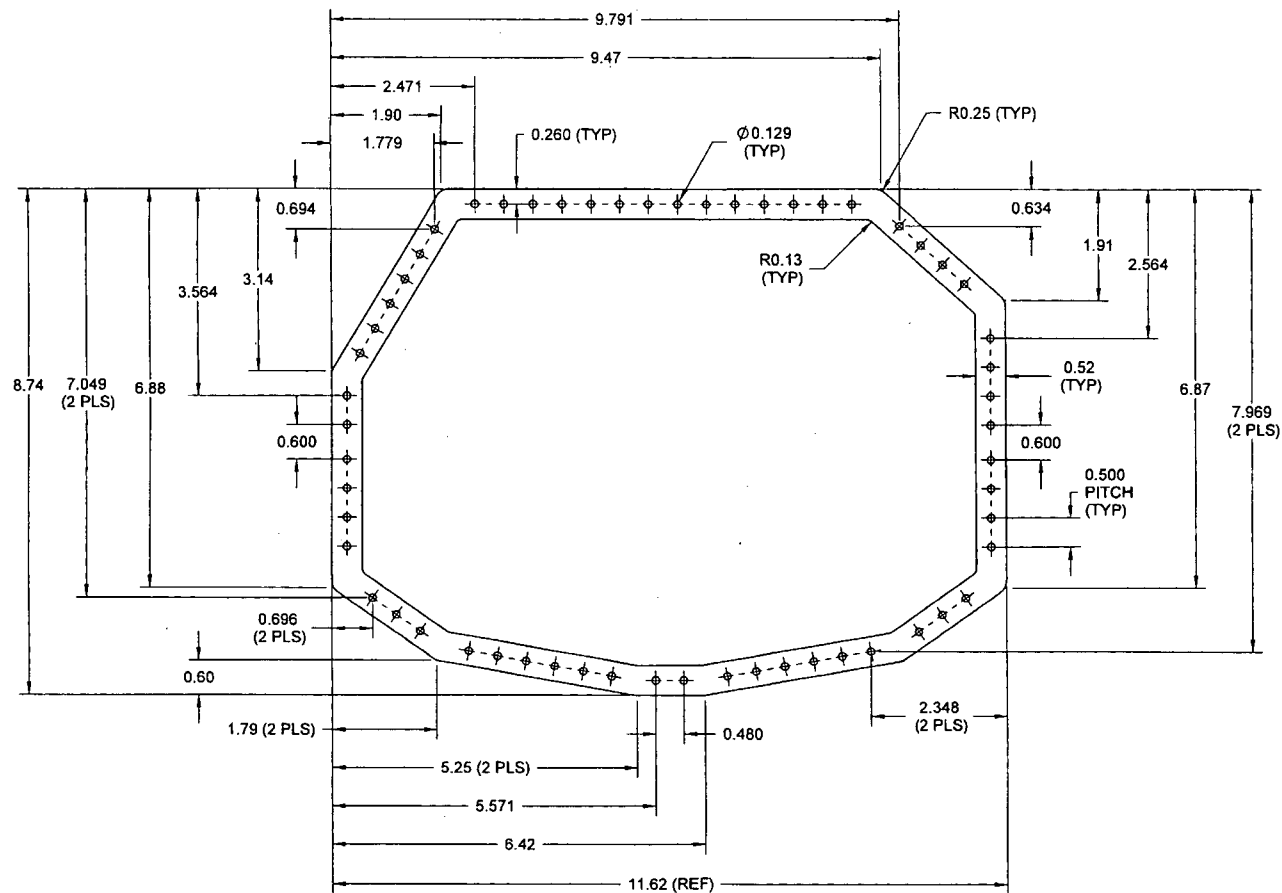
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

**D3651-11 GASKET**



DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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**D3651-13 OUTSIDE DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

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